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C3-10-2

Job Sheet 175627



Part No: C3-10-2

Job Qty: 10 ea

Part Name: Lock Spring



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/9/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-10-2 Rev 1A IPP Rev A 18.04.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		4/28/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	10 pcs		4/30/18	0.00	0.50	Small Fab-9		MLC 38
110	QC	10 pcs		4/30/18	0.00	0.00	QC5		38
130	Packaging	10 pcs		4/30/18	0.00	0.00	Packaging3-2		GA-Alain 18-06-12
140	QC21-FG	10 Ea		4/30/18	0.00	0.00	QC21		DAG

Part Op 100 - Cut spring to Size and form ends. See note 1.

Descriptions: 130 - Identify and Stock

21
9-09

JUN 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
9665K57	Extension Spring, SS, 20" Long x 0.25" OD x 0.02" Dia.	1.6600 ft (.166 ea)	90-Start up Operation	5060726

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	9665K57 47	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

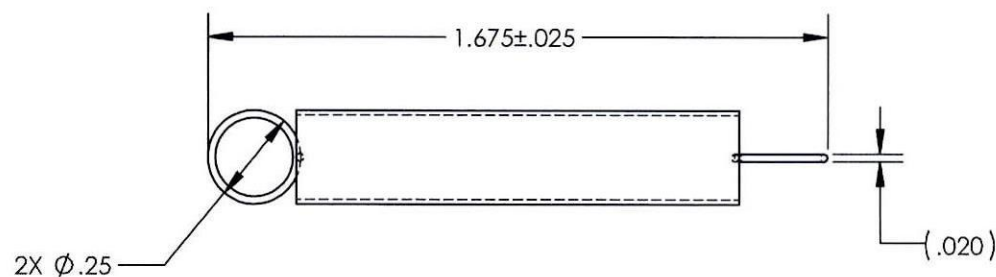
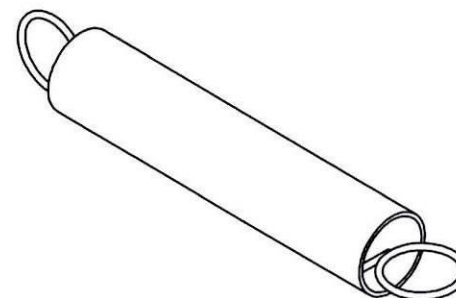
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. _____		Rework ☐		Skid-tube ☐		Cross tube ☐		Water Jet ☐		Engineering ☐	
NCR No. _____		Scrap ☐		Machining ☐		Small Fab ☐		Prod. Eng. Coord. ☐		Quality ☐	
		Use-as-is ☐		Thermoforming ☐		Finishing ☐		Rec/Store/Packaging ☐		Other ☐	
		Suspected Unapproved ☐		Large Fab ☐		Composite ☐		Supplier ☐			
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval			
Description Work Order Deviation						ition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐						Completed By					
						Lead hand / Supervisor Approval Verification					
						QC / QA Coordinator Approval					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐						Power Loss/Surge ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM	8/21/2012	JAG	
1A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED BAG & LABEL NOTE.	8/7/2014	DJN	RW



NOTES:

1. THE "EYES" AT THE ENDS MUST BE 90° OF EACH OTHER.
2. BAG & LABEL WITH BATCH NUMBER.

DART AEROSPACE	
TITLE LOCK SPRING	
DWG NO. C3-10-2	REV 1A
MAT'L S.S.	DRAWN BY:
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weid</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .016R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT FINISH SPEC
SCALE 2:1	DATE 9/20/2002
USED ON MODEL	
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			C3-10-2	1	LOCK SPRING	S.S.	Ø.25 OD X Ø.020 WIRE MCMaster-CARR #9665K57 (MODIFIED)	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					